

MiniTools 2 for Precision Boring Heads

**Caution: General safety regulations and directions of machine manufacturers must be observed at any time!**

Material description	W-Nr. German	AISI/SAE	Tensile strength	Hardness
1 Low Carbon Steel	1.0035	1010	- 500	- 160
	1.0038	1045		
	1.0401	1015		
	1.0050	1050		
2 Alloy Steel	1.0501	1035	500 - 700	140 - 200
	1.1141	1115		
	1.5732	3415		
	1.7225	4140		
3 Tool Steel	1.1221	1060	900 - 1'100	170 - 275
	1.3505	52100		
	1.7225	4140		
	1.5141	-		
4 Alloy Tool Steel	1.1191	4140	700 - 900	250 - 325
	1.7225	4142		
	1.2080	D3		
	1.7220	4135		
5 Alloy Cast Steel	1.6582	4340	1'100 - 1'500 800 - 1'000	325 - 450 250 - 300 330 - 390
	1.8159	6150		
	1.2367	A2		
	1.7361	4145		
6 Stainless Steel	1.4006	403	- 800	- 250
	1.4057	431		
	1.4034	420		
	1.4005	416		
7 Stainless Steel - Austenitic, Martensitic	1.4300	302	500 - 1100	200 - 325
	1.4301	304 (304H)		
	1.4435	316		
	1.4542	17-4 ph		
8 Grey Cast Iron	0.6010	A48-20B	- 250	- 200
	0.6015	A48-25B		
	0.6020	A48-30B		
9 Cast Iron Malleable	0.6025	A48-35B	250 - 350	200 - 250
	0.8135	A48-40B		
	0.8140	A48-45B		
	0.7050	80-55-06		
10 Copper Alloys	2.0331	B121	450 - 650	120 - 180
	2.0401	B121		
	2.1030	B103		
	2.0920	CuAl 8		
11 Aluminium Alloys	3.2582.05	383.2 (ALSI-12)	250 - 350	200 - 300
	3.3541.01	514.0 (AlMg 3)		
	3.2315	413.0 (AlMgSi 1)		
	3.0205	1200 (AL 99)		

 WCET FN-20    WCGT EN    WCGT FL    WCGT FN    WCGT FN-20					Carbide				Cermet			
					uncoated		coated		un coated	coated		
f (mm/U) *)					DX2		DX20	DX30 DX50		DT55	DT255	DT355
Vc (m/min)												
.0012	.0020	.0012	.0012				1120	1255		1520	1915	1915
.0039	.0059	.0039	.0039				955	1055		1220	1550	1550
.0012	.0020	.0012	.0012				1120	1190		1450	1815	1815
.0039	.0059	.0039	.0039				955	990		1150	1450	1450
.0012	.0020	.0012	.0012							1350	1685	1685
.0039	.0059	.0039	.0039							1120	1385	1385
.0012	.0020	.0012	.0012							725	890	890
.0039	.0059	.0039	.0039							660	790	790
.0008	.0020	.0008	.0008							595	725	725
	.0039									495	625	625
.0012				.0004			530	560				
.0039				.0024			460	530				
.0008				.0004			395	430				
.0039				.0024			330	365				
	.0020	.0012	.0012				460	860		825	1120	1190
	.0059	.0031	.0031				395	725		725	925	1055
	.0020	.0012	.0012					725		695	925	1055
	.0059	.0031	.0031					660		625	860	925
.0012				.0004		1485	1815	180				
.0039				.0031		1320	1650	1815				
.0008				.0004								
.0059				.0039		>3300		>6270				
.0079				.0079				>6600				

\*) in function of stability of tool & workpiece

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